

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020674**Date Inspected:** 12-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang, CWI as Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; 13E

PCMK: SEG3019BB

Weld No: 037

Welder: 05808

Weld Repair: CWR2737

WPS-345-SMAW-2G(2F)-FCM-Repair-1

NDE Report No. B787-UT-18549R1

Components; 13E

PCMK: DP3164-001

Weld No: 155

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Welder: 066422
Weld Repair: WR20222
WPS-345-SMAW-3G(3F)-FCM-Repair-1
NDT Repair No. B787-UT-1P210

Components; 13E
PCMK: DP3167-001
Weld No: 248.249
Welder: 066422
WPS-B-P-2212-TC-U4b-F

Components; 13E
PCMK: SEG3019L-1
Weld No: 001
Welder: 020222
Weld Repair: CWR20222
WPS-345-SMAW-2G(2F)-FCM-Repair-1

This Caltrans QA Inspector observed at random intervals ZPMC Performing grinding of welds SEG3019D-1-323. It appears that ZPMC is performing contour grinding. It appears that ZPMC is performing grinding of Visual rejects were ZPMC QC had marked rejectable VT indications.

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Carbon Arc Cutting (CAC) process.
ZPMC QC is identified as Zhong Yong Gang, CWI as Sha Zhi.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

This Caltrans QA Inspector during random observation at ZPMC noted that back gouging was being performed using the Carbon Arc Cutting (CAC) process on SEG3019D. Also noted at this location was ZPMC grinding these back gouge areas to a bright metal finish in preparation for the welding process as outlined in the contract documents. (see photo below)

Components; FB3286 to Floor Plate (see photo below)
PCMK: SEG3019D-1
Weld No: 323
Weld Repair: CWR2678
NDE Report No. B787-UT-18530
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer